

Split

HAI Ship 14/02/14

Work Order ID 112899

112899

Page 1

Item ID: D5024-041 -2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Instrument Panel Cap Assembly

Start Date: 11/02/2014 Start Qty: 1.00

1

Cust Item ID:

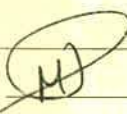
Required Date: 13/02/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-02-10

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5024

A

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut D5024-1f as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

3

0

Ae

14-02-10

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

3

0

Ae

14-02-10



Work Order ID 112899

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Page 2

Item ID: D5024-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Instrument Panel Cap Assembly

Start Date: 11/02/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/02/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

140

Small Fab

Memo

0.00

0.00

Small Fab

1- C'SINK RIVET HOLES AS PER DWG

2- BEND AS PER DWG

DAS
30
9-89

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

pro

FF

14-02-11

14/02/11

Work Order ID 112899

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Page 3

Item ID: D5024-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Instrument Panel Cap Assembly
 Start Date: 11/02/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 13/02/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						3	76	14-2-11	
HandFinish	Memo	0.00							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00			DAS				
170					30	3			14/02/11
QC	Memo	0.00			9-89				
Quality Control									
250		0.00							
250						①			FF 14-02-10
Small Fab	Memo	0.00							
Small Fab	INSTALL NUT PLATE AS PER DWG								

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February-10-14 1:24:50 PM

Item ID: D5024-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Instrument Panel Cap Assembly
 Start Date: 11/02/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 13/02/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 *260* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			
270 *270* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo ***INSTALL SCREW IN NUTPLATE BY HAND PRIOR TO POWDERCOATING*** START TIME: 11:00 OVEN TEMPERATURE: 320° FINISH TIME: 11:30	0.00 0.00				1	14-2-19		
280 *280* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			

DAS 34 9-89

Work Order ID 112899

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Page 5

Item ID: D5024-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Instrument Panel Cap Assembly

Start Date: 11/02/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/02/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

Identify as per dwg & Stock Location: 8T191

0.00

290

Packaging

Memo

0.00

Packaging

1x 14-2-21

DAS
26
9-89

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

14-02-21

14-02-21

Print

January-10-14 1:24:56 PM

Page 1

Work Order ID: 112899

Parent Item: D5024-041

Parent Item Name: Instrument Panel Cap Assembly

112899

D5024-041

Start Date: 11/02/2014

Required Date: 13/02/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	228.8800		2			
										**		A 14-02-10	
M6061T6S 080													
6061-T6 .080 Sheet													

MS21075L3	MS21075L3N	Purchased	No										
MS21075L3													
Nut Plate													
MS20426AD3-4		Purchased	No										
MS20426AD3-4													
RIVET													

Location

MAT021

m126309

m126350

m128257
127993

Loc Qty

228.88

213.62

15.26

Each

Loc Code

0.0000

**

8 24

72

FF 14-02-18

(6)

Location

ST334

m127432

ST509

125578

Loc Qty

4000

4000

6337

6337

Loc Code

7796

FF 14-02-13

DART AEROSPACE LTD		Work Order:	112899
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

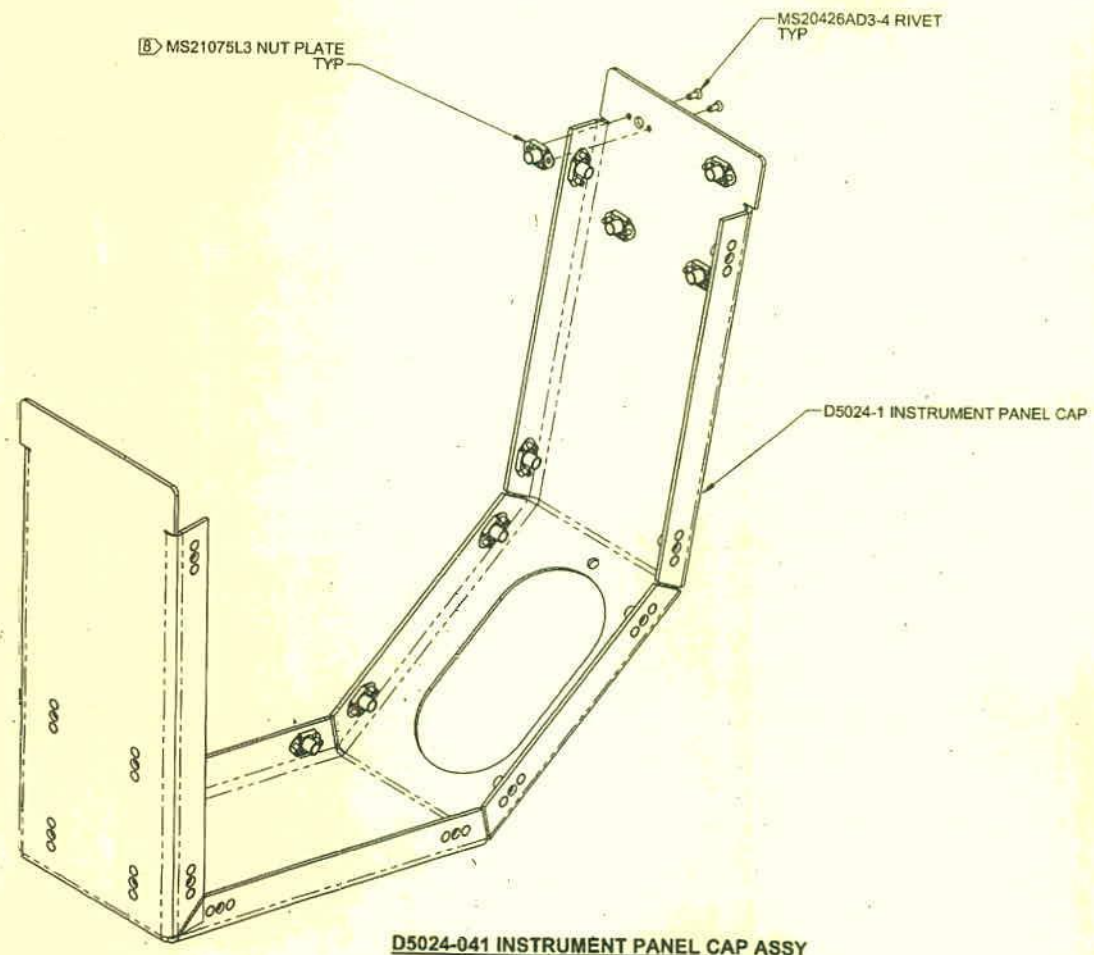
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+0.004/-0.001	.098	-		✓	Jkm-05
Ø .201	+0.005/-0.001	.203	-		✓	
.330	+/- .010	.330	-		✓	
.68	+/- .030	.68	-		✓	
1.579	+/- .010	1.579	-		✓	
2.58	+/- .030	2.58	-		✓	
2.000	+/- .010	2.000	-		✓	
4.48	+/- .030	4.48	-		✓	
4.828	+/- .010	4.828	-		✓	
5.16	+/- .030	5.16	-		✓	
2.500	+/- .010	2.500	-		✓	
2.000	+/- .010	2.000	-		✓	
.75	+/- .030	.75	-		✓	
31.50	+/- .030	31.50	-		T	Jkm-06
30.50	+/- .030	30.50	-		T	
29.697	+/- .010	29.697	-		T	
28.847	+/- .010	28.847	-		T	
24.051	+/- .010	24.051	-		T	
23.11	+/- .030	23.11	-		T	
22.176	+/- .010	22.176	-		T	
21.30	+/- .030	21.30	-		T	
19.30	+/- .030	19.30	-		T	
18.416	+/- .010	18.416	-		T	

Measured by:	Ac	Audited by:	27	Preliminary Approval:	
Date:	14.02.10	Date:	14.2.11	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D5024-041 INSTRUMENT PANEL CAP ASSY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5024-041	INSTRUMENT PANEL CAP ASSY
1	1	D5024-1	INSTRUMENT PANEL CAP
2	24	MS21075L3	NUT PLATE, SELF-LOCKING, FLOATING
3	48	MS20426AD3-4	RIVET, CSK

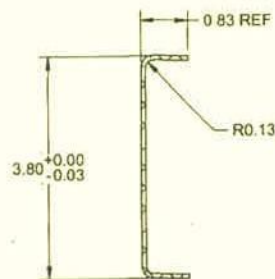
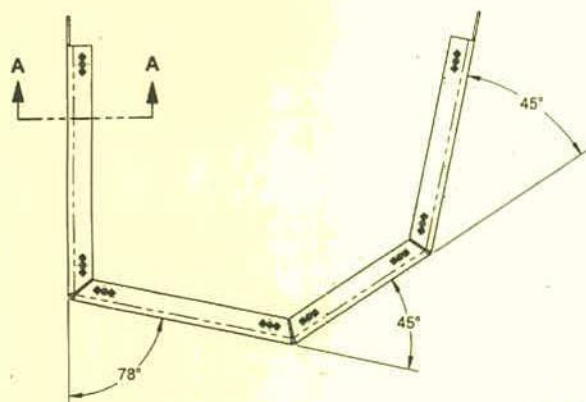
SHOP COPY
 RETURN TO:
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 112899 MP
 14-02-10

RELEASED
 2013-01-24
 MP

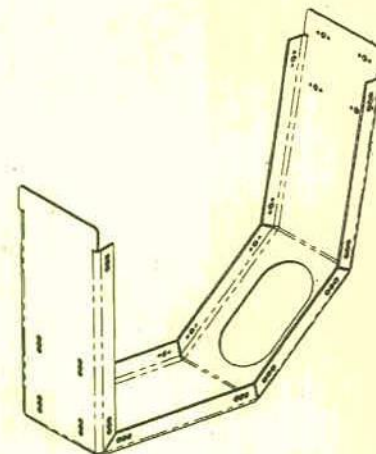
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.21 lbs
 - 8) MASK NUTPLATE THREADS PRIOR TO PAINTING

APPROVED

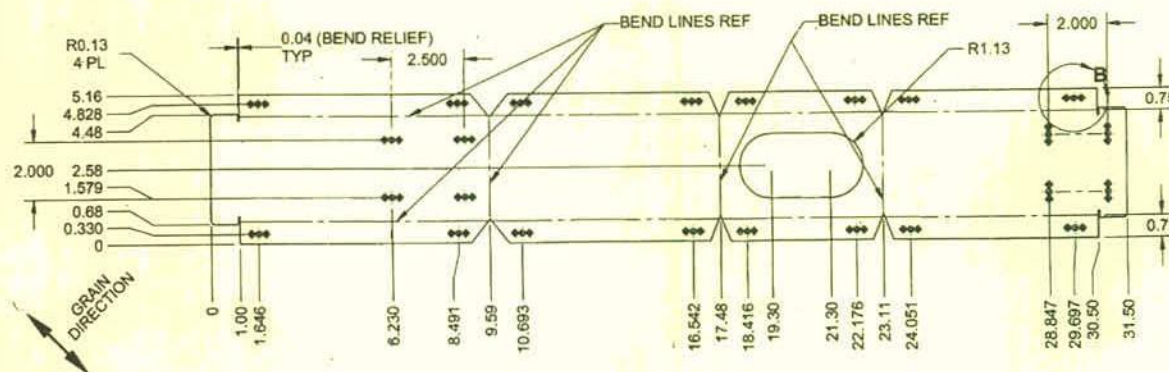
A	NEW ISSUE	DB	13.12.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. A
MFG. APPR.	DD	D5024	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	INSTRUMENT PANEL CAP	NTS
DATE	14.01.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE, REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



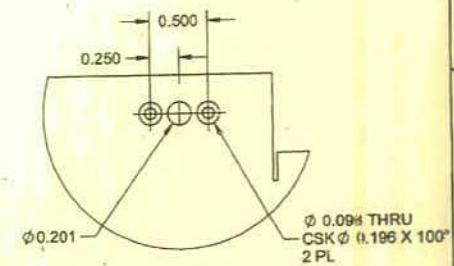
SECTION A-A
SCALE 2X



D5024-1 INSTRUMENT PANEL CAP
(MAKE FROM D5024-1F)



D5024-1F FLAT PATTERN



DETAIL B
SCALE 4X
24 PL

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: D5024-1: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
D5024-1F: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.15 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5024-1F-A.DXF"

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. A
MFG. APPR.	DD	D5024	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	INSTRUMENT PANEL CAP	NTS
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